

Date: Sunday, 12/4/2005 12:45:11 PM  
 User: Linda Lacelle

## Process Sheet

|                       |                                       |          |                  |                  |               |          |
|-----------------------|---------------------------------------|----------|------------------|------------------|---------------|----------|
| Customer              | : CU-DAR001 Dart Helicopters Services |          | Drawing Name     | : STEP SPACER    |               |          |
| Job Number            | : 25089C                              |          |                  |                  |               |          |
| Estimate Number       | : 10354                               |          |                  |                  |               |          |
| P.O. Number           | : N/A                                 |          |                  | Part Number      | : D2322       |          |
| This Issue            | 12/4/2005                             | S.O. No. | N/A              | Drawing Number   | : D2322 REV C |          |
| Prsht Rev.            | : NC                                  |          |                  | Project Number   | : N/A         |          |
| First Issue           | N/A                                   | Type     | Mechanical parts | Drawing Revision | : C           |          |
| Previous Run          | : 24533C                              |          |                  | Material         | : N/A         |          |
| Written By            | : SEE COMMENT Below                   |          |                  | Due Date         | : 12/12/2005  |          |
| Checked & Approved By | : SEE COMMENT Below                   |          |                  | Qty:             | 30            | Um: Each |
| Comment               | : Est Rev:A New Issue 05-11-07 JLM    |          |                  |                  |               |          |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description :  |             |    |
|---------|-----------------------|--|-------------|----|
| 1.0     | M2024T3S040           | 2024-T3 .040 sheet   |             |    |
|         |                       |  |             |    |
|         |                       | Comment: Qty.: 0.2132 sf(s)/Unit Total : 4.2630 sf(s)<br>Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick<br>(M2024T3S.040)<br>Identify as D2322<br>Batch: M19059 |             |    |
| 2.0     | SHEAR                 | SHEAR J.L.   | 05-12-11    | 30 |
|         |                       |  |             |    |
|         |                       | Comment: SHEAR<br>Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500")  |             |    |
| 3.0     | HAAS1                 | HAAS CNC VERTICAL MACHINING #1 J.L.  | 05-12-11    | 30 |
|         |                       |  |             |    |
|         |                       | Comment: HAAS CNC VERTICAL MACHINING #1<br>Machine as per folio D2322, use stack of 15   |             |    |
| 4.0     | QC2                   | INSPECT PARTS AS THEY COME OFF MACHINE J.L.  | 05-12-11    | 30 |
|         |                       |  |             |    |
|         |                       | Comment: INSPECT PARTS AS THEY COME OFF MACHINE  |             |    |
| 5.0     | QC8                   | SECOND CHECK   |             |    |
|         |                       |  |             |    |
|         |                       | Comment: SECOND CHECK  | on 05/12/11 | 30 |

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/01/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Sunday, 12/4/2005 12:45:12 PM  
User: Linda Lacelle

## Process Sheet

|   |                       |  |
|---|-----------------------|--|
| Customer: CU-DAR001 Dart Helicopters Services   |                       | Drawing Name: STEP SPACER                        |
| Job Number: 25089C  |                       | Part Number: D2322                               |
| Job Number:   |                       |  |
| Seq. #:   | Machine Or Operation: | Description :                                    |
| 6.0   | SMALL FAB 1           | SMALL & MEDIUM FAB RESOURCE 1                    |
|   |                       |  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1  |                       |  |
| Deburr <span style="float: right;">SAD 1 m 11/05 / 38</span>  |                       |  |
| 7.0   | BRAKE NC              | NC BRAKE   |
|   |                       |  |
| Comment: NC BRAKE   |                       |  |
| Form as per Dwg D2322 <span style="float: right;">SB 06/01/16 30</span>   |                       |  |
| 8.0   | QC5                   | INSPECT WORK TO CURRENT STEP                     |
|   |                       | <span style="float: right;">J 06-01-16</span>    |
| Comment: INSPECT WORK TO CURRENT STEP   |                       |  |
| 9.0   | HAND FINISHING1       | HAND FINISHING RESOURCE #1                       |
|   |                       |  |
| Comment: HAND FINISHING RESOURCE #1   |                       |  |
| Chemical Conversion Coat as per QSI 005 4.1 <span style="float: right;">SAD 06/01/18 30</span>                        |                       |  |
| 10.0  | QC3                   | INSPECT POWDER COAT/CHEMICAL CONVERSION          |
|   |                       | <span style="float: right;">J 06-01-18 30</span> |
| Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  |                       |  |
| 11.0  | PACKAGING 1           | PACKAGING RESOURCE #1                            |
|   |                       |  |
| Comment: PACKAGING RESOURCE #1  |                       |  |
| Identify and Stock  |                       |  |
| Location: 37 <span style="float: right;">/ 06/01/12 30</span>   |                       |  |
| 12.0  | DC                    | DOCUMENT CONTROL                                 |
|   |                       |  |
| Comment: DOCUMENT CONTROL   |                       |  |
| Inspection Level 21 <span style="float: right;">SAC 06/01/19 30 </span> <span style="float: right;">S 06/01/19</span> |                       |  |
| Job Completion  |                       |  |

| W/O: |      | WORK ORDER CHANGES |  |  |    |      |     |                                     |                          |
|------|------|--------------------|--|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |  |    |      |     |                                     |                          |
|      |      |                    |  |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

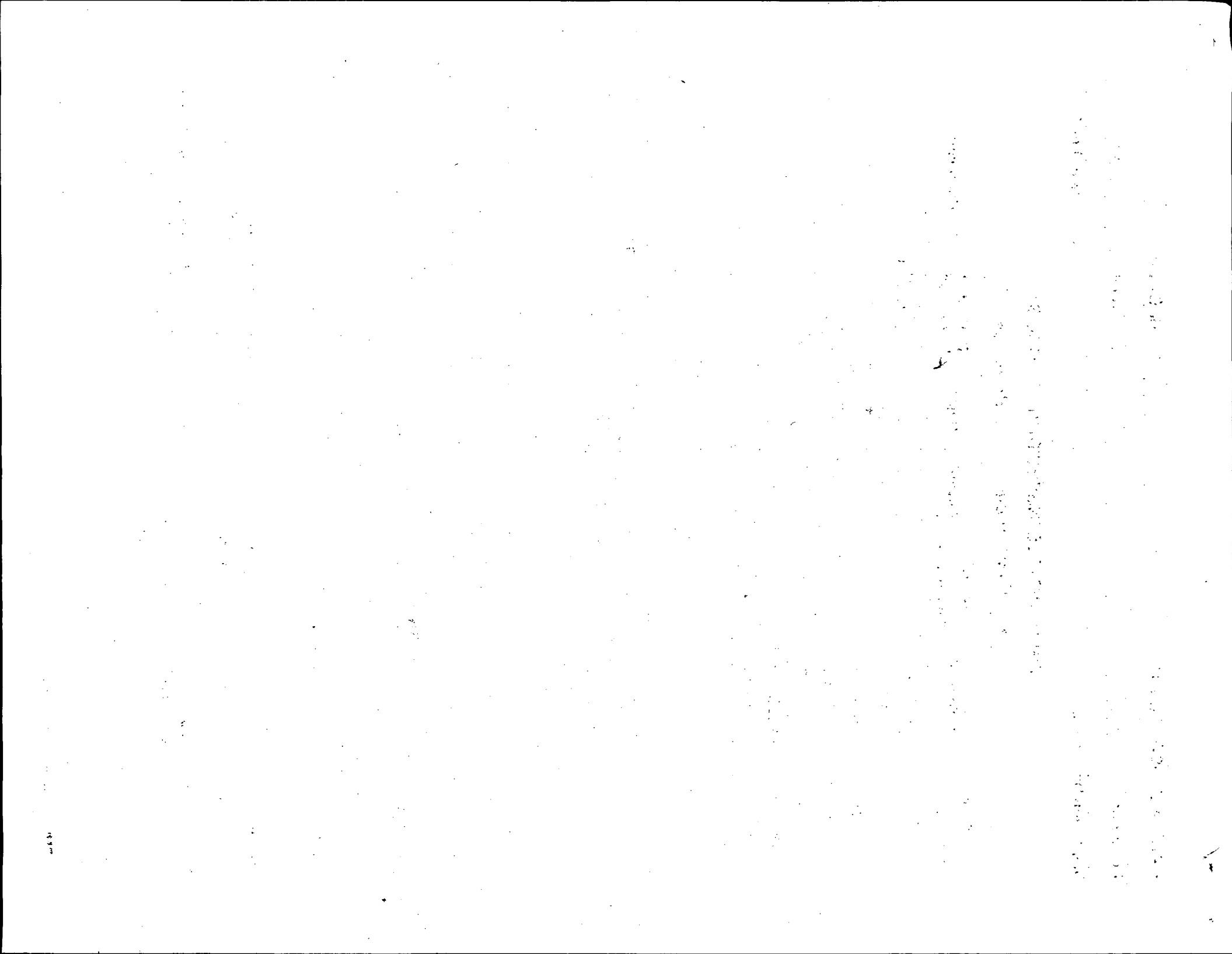
|                          |              |             |
|--------------------------|--------------|-------------|
| DART AEROSPACE LTD       | Work Order:  |             |
| Description: Step Spacer | Part Number: | D2322       |
| Inspection Dwg: D2322    | Rev: C       | Page 1 of 1 |

## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

|              |          |             |          |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | J.L      | Audited by: | M        | Prototype Approval: | N/A |
| Date:        | 05.12.11 | Date:       | 05.12.11 | Date:               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b>       | <b>Revised by</b> | <b>Approved</b> |
|------------|-------------|---------------------|-------------------|-----------------|
| A          | 04.10.12    | New Issue P/O D2582 | KJ/JLM            |                 |



**DART**

| DESIGN<br>BW         | DRAWN BY<br><i>GP</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA       |
|----------------------|-----------------------|---|
| CHECKED<br><i>KE</i> | APPROVED<br><i>MH</i> | DRAWING NO.<br>D2322                                    |
| DATE<br>98.09.29     |                       | REV. C<br>SHEET 1 OF 1                                  |
| A<br>98.09.29        | 94.10.14              | STEP SPACER   |
| C<br>98.09.29        | 94.10.14              | 4.428 WAS 4.460, 0.040 WAS 0.032<br>CHANGES PER NCR 001 |

**RELEASED**  
18.10.08 DS

UNDER REVIEW

12/03/15 GP

DESIGN OK, BUT CHECK WITH  
MANUFACTURE  
FOR FURTHER  
MANUFACTURING

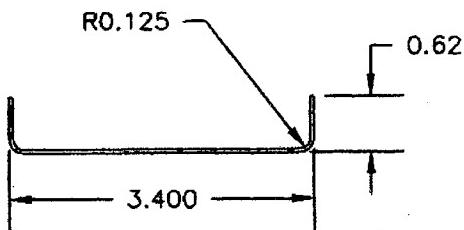
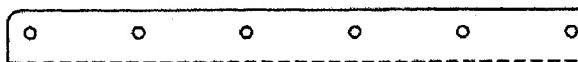
OK FOR MFG

Ø0.128 (TYP 12 PLACES)

Ø0.125  
(TYP 4 PLACES)  
REF ID: 06

GRAIN DIRECTION

FLAT LAYOUT

R0.125  
0.62  
3.400

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED